

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011691**Date Inspected:** 21-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # CROSS BEAM CB01

This crossbeam is completed and was shipped.

OBG # CROSS BEAM CB02

This crossbeam is completed and was shipped.

OBG # CROSS BEAM CB03

This crossbeam is completed and was shipped.

OBG # CROSS BEAM CB04

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

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OBG # CROSS BEAM CB05

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB06

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB07

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB08

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB09

This QA observed ZPMC qualified welding personnel identified as 053753 perform Shielded Metal Arc Welding (SMAW) Process repair welding on weld joint CB202A-009-011. ZPMC Quality Control Personnel (QC) identified as Mr. Liu Chuan Gang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair and approved Critical Weld Repair (CWR) B-CWR1038.

This QA observed ZPMC qualified welding personnel identified as 053753 perform Shielded Metal Arc Welding (SMAW) Process repair welding on weld joint CB202A-009-005. ZPMC Quality Control Personnel (QC) identified as Mr. Liu Chuan Gang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair and approved Critical Weld Repair (CWR) B-CWR1039.

OBG # CROSS BEAM CB10

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB 11

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

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OBG # CROSS BEAM CB12

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB13

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB14

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB15

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB16

This QA observed that ZPMC personnel performing heat straightening on North side of bottom panel identified as BP201A and BP203A. ZPMC QC identified as Mr. Shen Jian Guo was present to monitor the heat straightening process. Mr. Shen Jian Guo informed this QA that a heat straightening being performed to correct the deformation. No other significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB17

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

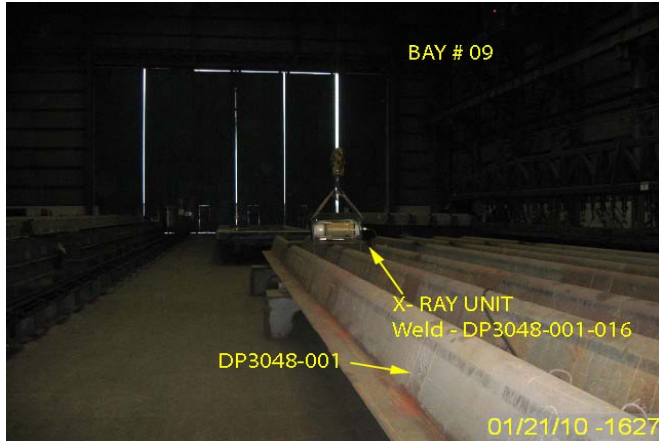
OBG # BAY 09

This QA observed that ZPMC Radiography (RT) personnel identified as Mr. Yunshu performing RT on Deck Panel weld joint is identified as DP3048-001-016. RT technique appeared to be in general compliance with the contract documents during the time QA was present. See attached picture.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

As mention above

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By:	Sukanthan,Dhanasingh
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Quality Assurance Inspector

Reviewed By:	Hall,Steven
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QA Reviewer
